

Work Order ID 61042

August 4, 2010 2:32:38 PM



Page 1

Item ID: D206-642-441

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 8/04/10 Start Qty: 1.00



Cust Item ID:


Required Date: 8/16/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: 

Date: 10-8-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2650

Rev F

100

0.00



DC

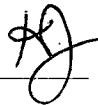
DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

N/A 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Revision ID:

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Start Date: 8/04/10 Start Qty: 1.00

Required Date: 8/16/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110



Skidtubes

Skidtubes

Skidtubes

Memo

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R ☐ Aluminum Rod ☒ M114242 / M112507 BE 10/08/104-Grind weld flush to cap on top surface only. BE 10/08/10

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubes as per Dwg D2650

11-Deburr and Blow out all chips from inside the tube

> DP 10-8-10

DP
BE

10-8-11

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

(IX) 2 MB 10-08-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 8/04/10 Start Qty: 1.00



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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail
(without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs.
cure time before cutting☐

Start Date: 10-8-12

Time: ☐ 10:30AM☐

Finish Date: 10-5-16

Time: ☐ 7:30AMA/R ☐ Sikaflex-291 ☐ M115114 ☐Sikaflex expiry date: ☐ 11-1-30

10-8-12

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 8/16/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

8/10/06/16

40

Memo

160



Skidtubes

Skidtubes

Skidtubes

0.00

0.00

Memo

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.
A/R Aluminum Rod M112507

2-Grind welds flush as per Dwg D2650.

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Deburr

BE 10/08/08

DP 10-8-19

W/O:		WORK ORDER CHANGES					
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Start Date: 8/04/10 Start Qty: 1.00



Cust Item ID:

Required Date: 8/16/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

0.00



HandFinishing

Skidtubes

Memo

0.00

Skidtubes

Install D2680-041 Nut Plate as per Dwg D2650

DP 10-8-19

180

0.00



QC10- Inspect visual per QSI004- ground welds

QC

Memo

0.00

Quality Control

8/10/08/19

190

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8/10/08/19

FC

W/O:		WORK ORDER CHANGES					
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Reference:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

✓ Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

7M 10/09/20

1 6

205

Primer 2 114424
Deflect Blue 113171
Clear Deflect 115506

0.00



SprayPaint

Memo

0.00

Spray Painting

mml 10 09 02 (1)

206

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

ZT 10-09-03 (cl)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Date: 8/16/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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230

0.00



HandFinish

HandFinishing

0.00

⇒ M. 10/09/07

1

0

Hand Finishing

Memo

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

✓ A/R ☐ Sikaflex-291 ☐ M114093Sikaflex expiry date: ☐ 10/10

✓ 2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

✓ 3-Install MS27039-4-06 Screw as per DEO 9153

✓ 4-Inspect for foreign object per QSI 024

✓ 5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R ☐ Sikaflex-291 ☐ M114093Sikaflex expiry date: ☐ 10/10

✓ 6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch: M115028

W/O:		WORK ORDER CHANGES					
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Work Order ID 61042

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Item ID: D206-642-441

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Setup Start



Revision ID:

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Item Name: Replacement Skidtube

Start Date: 8/04/10 Start Qty: 1.00



Cust Item ID:

Required Date: 8/16/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/04/10



Quality Control

250

Packaging

0.00



Packaging

Memo

0.00

Identify and pack for shipping as per PPP D206-642-441

Location: _____

PPP Rev: _____

PPP 61052

8/04/10

260

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

10/09/09

Quality Control

8/10-9-08

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 61042

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube





Start Date: 8/04/10

Required Date: 8/16/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H 05.10.11 Added D3429-1 per CHG002 KJ/CP/JLM
IPP Rev:I 08-05-01 add QC3 DD verified by:EC
IPP Rev:J 08-09-29 revF as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2620  Skidtube, 206 Skidtube		Manufactured	No			110	Each	8.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG</div> <div>57542</div> <div>1</div> <div>8</div> <div>8</div> </div>													
D2646  Aft Cap		Manufactured	No			110	Each	79.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>FP-4</div> <div>57332</div> <div>70</div> <div>70</div> </div>													
<div> <div>FP6</div> <div>52663</div> <div>9</div> <div>9</div> </div>													
D2647  Cap		Manufactured	No			140	Each	76.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>FP</div> <div>55352</div> <div>76</div> <div>76</div> </div>													
D2654-7  Web		Manufactured	No			160	Each	0.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													

B 612 64

①

DP 10-8-12

DP 10-8-10

10/09/07

BE 10/08/10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 8/04/10

Required Date: 8/16/10

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased No

170

Each

532.0000

2

2



Cherry Rivet



Location

Loc Qty

Loc Code

ST311

532

112314

4

113539

60

113973

468

(2)

23 23 10-8-19

D2649

Manufactured No

170

Each

140.0000

23

23



Cross Bolt Spacer



Location

Loc Qty

Loc Code

LG

140

58545

12

60652

128

23 8E 10/08/10

D2680-041

Manufactured No

170

Each

39.0000

1

1



Nut Plate



Location

Loc Qty

Loc Code

ST021

39

55366

39

(1)

23 10-8-19

August 4, 2010 2:32:42 PM

Shop Packet Print

Page 2

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Parent Item Name: Replacement Skidtube

Start Date: 8/04/10

Required Date: 8/16/10

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130 Purchased

No

230

Each

3,842.000

60

60



10/09/07

Insert

Location

Loc Qty

Loc Code

PKG11

3602

114723

3602

x60

ST282

201

110511

38

114407

163

ST381

39

114654

39

AN960JD10L NAS1149D0332J Purchased

No

230

Each

2,635.000

62

62



10/09/07

Washer

Location

Loc Qty

Loc Code

ST348

2635

110985

2635

x62

AN960JD416 NAS1149D0463J Purchased

No

230

Each

0.0000

1

1



10/09/07

Washer

CR3212-4-03 Purchased

No

230

Each

1,926.000

2

2



Cherry Rivet

Location

Loc Qty

Loc Code

ST311

1926

111359

5

112314

2

114436

448

114450

89

114859

1382

②

10-8-19

August 4, 2010 2:32:42 PM

Shop Packet Print

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Work Order ID: 61042

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 8/04/10

Required Date: 8/16/10

Start Qty: 1.00

Required Qty: 1.00

D2651-1

Manufactured No

230

Each

748.0000

22

22



Plug



22 10/09/07

Location

Loc Qty

Loc Code

FP 152
51530 152
fpa 596
53349 411
57869 185

x22

D2651-3

Manufactured No

230

Each

356.0000

22

22



O-Ring



22 10/09/07

Location

Loc Qty

Loc Code

FP 356
46114 356

x22

D3535-15

Manufactured No

230

Each

10.0000

1

1



Wearshoe



1 10/09/07

Location

Loc Qty

Loc Code

FP18 10
59236 10

x1

D3535-23

Manufactured No

230

Each

1.0000

1

1



Wearshoe



1 10/09/07

Location

Loc Qty

Loc Code

FP21 1
57730 1

x1

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 4, 2010 2:32:42 PM

Work Order ID: 61042



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 8/04/10

Required Date: 8/16/10

Start Qty: 1.00

Required Qty: 1.00

D3535-37

Manufactured No

230

Each

17.0000

1

1



Wearshoe



10/09/07

Location

Loc Qty

Loc Code

FP

17

51654

4

56101

13

X1

D3536-15

Manufactured No

230

Each

25.0000

1

1



Gasket



10/09/07

Location

Loc Qty

Loc Code

FP

18

56055

6

60875

12

FP11

7

59238

7

X1

D3536-23

Manufactured No

230

Each

14.0000

1

1



Gasket



10/09/07

Location

Loc Qty

Loc Code

FP011

14

58819

2

60234

12

X1

D3536-37

Manufactured No

230

Each

15.0000

1

1



Gasket



10/09/07

Location

Loc Qty

Loc Code

FP

15

56102

15

X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 4, 2010 2:32:42 PM

Work Order ID: 61042

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 8/04/10

Required Date: 8/16/10

Start Qty: 1.00

Required Qty: 1.00

D3537-1 Manufactured No

230

Each

7.0000

6

6



Wearpad



24 10/09/07

Location

Loc Qty

Loc Code

FP

1

B61201

X6

55465

1

FP17

6

57713

3

59593

3

D3537-3 Manufactured No

230

Each

16.0000

1

1



Wearpad



24 10/09/07

Location

Loc Qty

Loc Code

FP19

16

X1

59711

16

MS27039-1-08 Purchased No

230

Each

1,763.000

2

2



Screw



24 10/09/07

Location

Loc Qty

Loc Code

ST291

1763

110835

563

X2

114718

200

115108

1000

MS27039-4-06 Purchased No

230

Each

25.0000

1

1



Screw



24 10/09/07

Location

Loc Qty

Loc Code

ST292

25

109061

25

X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 7

August 4, 2010 2:32:42 PM

Work Order ID: 61042



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 8/04/10

Required Date: 8/16/10

Start Qty: 1.00

Required Qty: 1.00

MS27039C1-08

Purchased

No

230

Each

1,058.000

60

60



44 10/09/07

SCREW

Location

Loc Qty

Loc Code

FP

1000

15336

1000

x60

ST293

58

19185

58

August 4, 2010 2:32:42 PM

Shop Packet Print

Page 7

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 610-12
DS10-8-04

RELEASED
08-07-23

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCCRP. DEO9136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AdS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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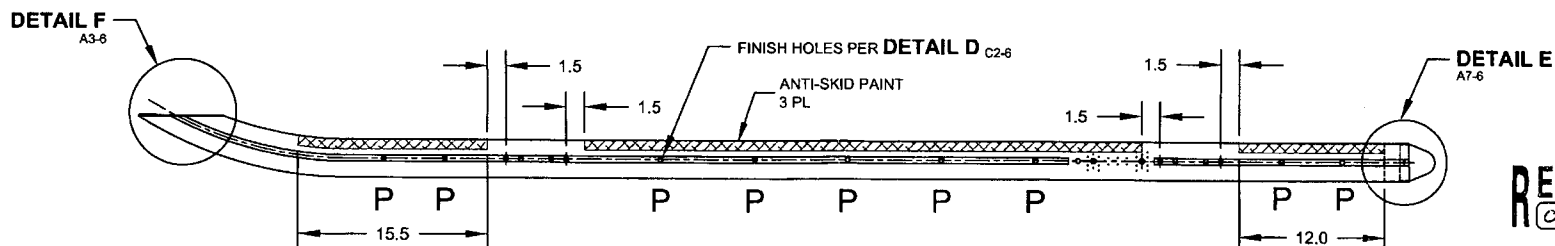
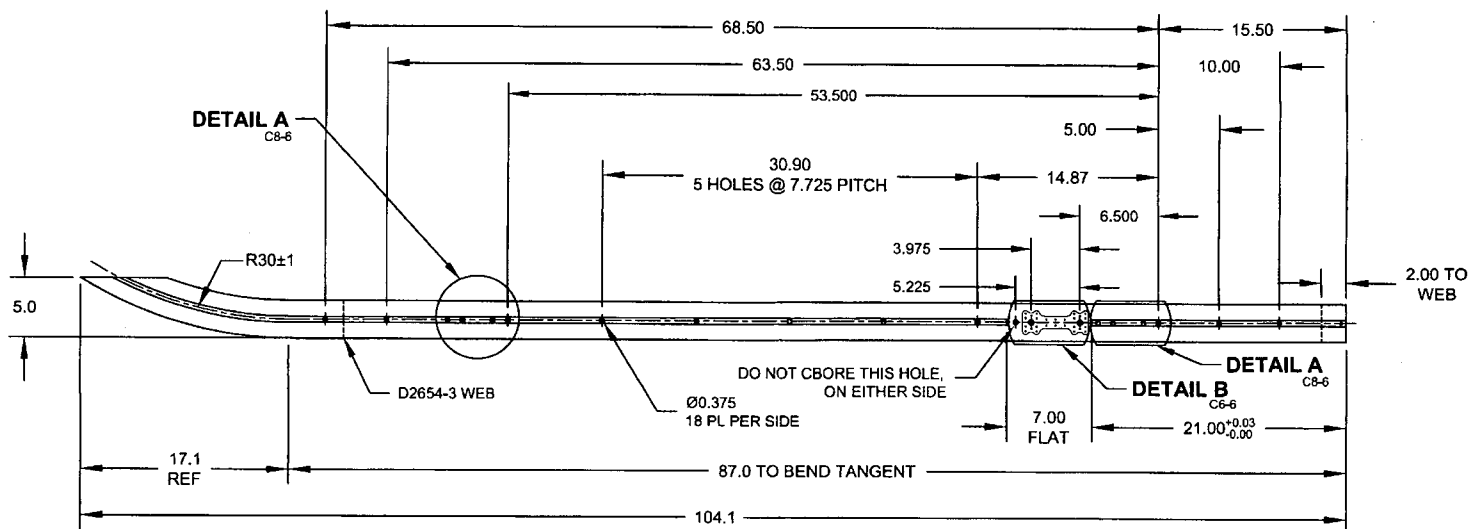
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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w/o 41042

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APPROVED	<i>[Signature]</i>	TITLE	SCALE
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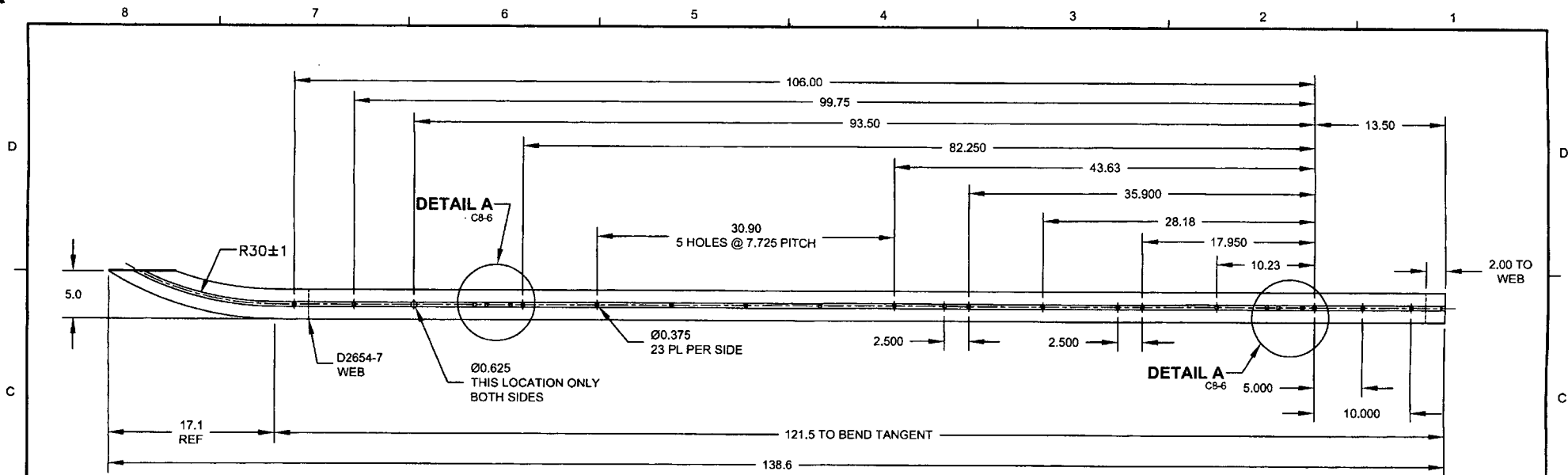
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

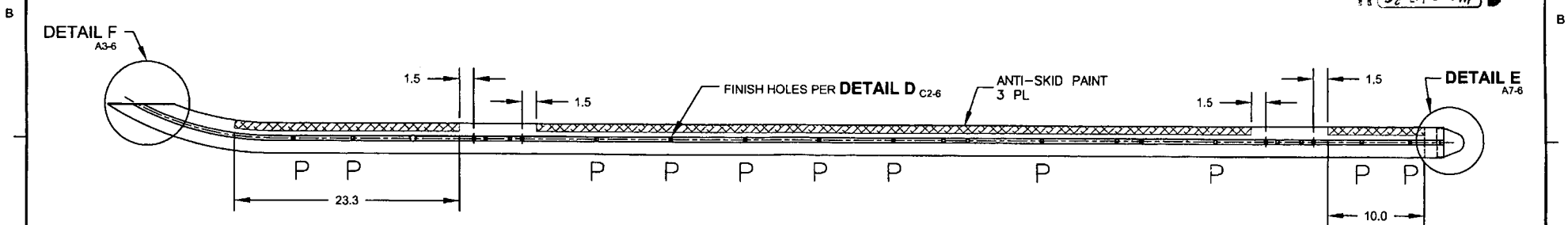
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D2650-7 BENDING/DRILL DETAIL



D2650-7 ASSEMBLY/FINISHING DETAIL

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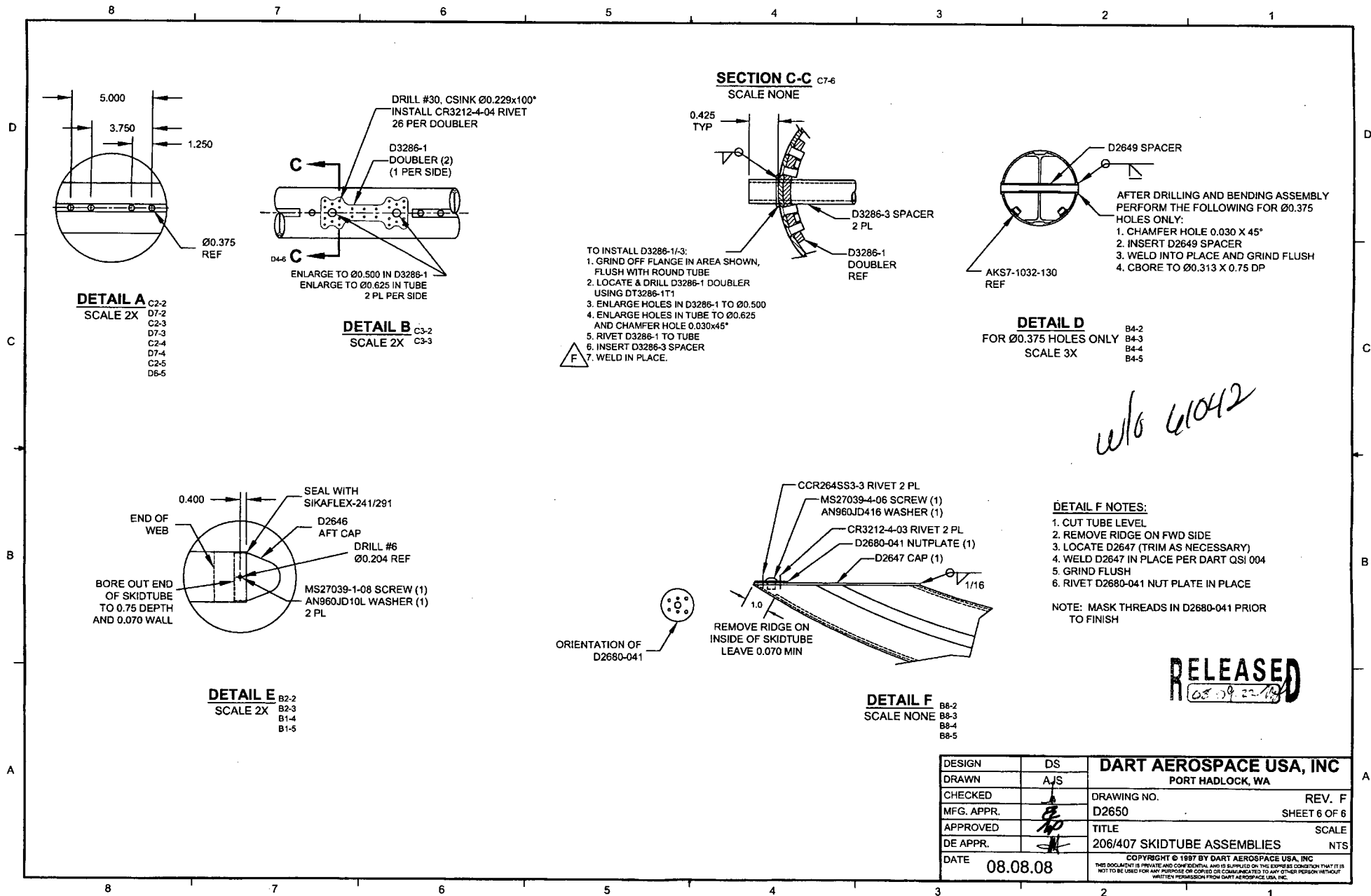
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NO. 231

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Berclay Elliott
Job number: 61039
Part number: D206-442-441
Description: 206 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Del Del Date of Test Coupon 10.08.19

Welder Berclay Elliott Date of Test Coupon 10.08.19

The above named individual is qualified in accordance with AWS D17.1.2001 to weld